

Work Order ID 74632

Tuesday, October 04, 2011 1:42:09 PM



Page 1

Item ID: D3913-041	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Long Basket Base Assembly, 350				
Start Date: 10/4/2011 Start Qty: 1.00		Cust Item ID:		
Required Date: 10/14/2011 Req'd Qty: 1.00		Customer:		
Reference:				

Approvals:	Process Plan: <u>MLJ</u>	Date: <u>11/10/04</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	A								
D4020	A								
100	Weld per dwg A/R S.S. rod Batch: <u>117884</u>	0.00							
	Large Fab								
Large Fab	Memo	0.00							
	1- assemble ribs , weld as per dwg D3913 using DT9610A								
	inspect before welding mesh								
	2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913								
	and trim mesh to fit if necessary and trim to clear fasteners holes on the ends								
	3- weld hinge (3) and Mounting brackets as per dwg D3913								
	take lid to locate hinge and bracket								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

PL 11.10.14

B.E. 11.10.14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Setup Start



Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop



Start Date: 10/4/2011 Start Qty: 1.00



Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

IXD M of 11/10/10

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				Customer:		

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	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat 1ST COAT: 2:15 START TIME: 4:00 OVEN TEMPERATURE: 400°F FINISH TIME: 2:45 ***** 2nd coat is necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00							IXP m-1 11/10/20
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							1 f 11/10/20

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	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish Hand Finishing	Assemble as per dwg Memo Pick Kit	0.00 0.00							
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>w/o</u> Memo	0.00 0.00							

1 1/2 11/10/20

8/11/20

D4036-041 | B71631

1x 11/10/20

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/27 *[Signature]*
CME
11-10-26

Dart Aerospace Ltd

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Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581



Mounting Bracket

Manufactured No

100

Each

18.0000

2

2



2
11.10.12

Location

Loc Qty

Loc Code

WA

18

69739

2

70766

2

73079

14

D3913-1



Rib

Manufactured No

100

Each

4.0000

1

1



1
11.10.12

Location

Loc Qty

Loc Code

WA

3

59089

1

69260

2

WA006

1

73647

1

374145 → ①

D3913-15



Wide Handle Plate

Manufactured No

100

Each

1.0000

1

1



1
11.10.12

Location

Loc Qty

Loc Code

WA005

1

69012

1

374317 → ①

Dart Aerospace Ltd

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Page 2

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3913-3
Rib
Manufactured No

100 Each 3.0000 1 1



PL 11.10.12

Location

Loc Qty

Loc Code

WA

3

~~69160~~

1

73533

2

100 Each 4.0000 2 2



PL 11.10.12

D3913-7
Rib
Manufactured No

Location

Loc Qty

Loc Code

WA

2

~~69521~~

2

WA006

2

~~65278~~

1

~~66435~~

1

100 Each 3.0000 1 1



B73648 -> 2

D3913-9
Hinge Rib
Manufactured No

Location

Loc Qty

Loc Code

WA

2

73530

2

WA006

1

~~70188~~

1

100 Each 2.0000 2 2



PL 11.10.12

D3916-041
Rib Assembly
Manufactured No

Location

Loc Qty

Loc Code

WA

2

~~69161~~

2

B74131 -> 2

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Page 2

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Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3916-5 Manufactured No

100

Each

5.0000

3

3



Light Rib

Location

Loc Qty

Loc Code

WA

5

5

100

Each

13.0000

3

3

D4016-1



Hinge Half, Base

Location

Loc Qty

Loc Code

WA

13

0

3

10

100

Each

1.0000

1

D4017-7



Rib

Location

Loc Qty

Loc Code

WA

1

1

100

Each

8.0000

2

2

D4017-9



Rib

Location

Loc Qty

Loc Code

WA

8

2

6

PL 11.10.12
B74639 → ①

②
PL 11.10.12

③
PL 11.10.12
B74077 → ①

PL 11.10.12
B74141 → ②

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Page 4

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

D4020-11

Manufactured No

100

Each

7.0000

2

2



End Mesh, Basket



Pl 11.10.12

Location

Loc Qty

Loc Code

WA

7

69648

2

74035

5

②

D4021-1

Manufactured No

100

Each

12.0000

3

3



Handle Plate



Pl 11.10.12

Location

Loc Qty

Loc Code

WA

6

69518

6

WA005

6

73649

6

③

D4034-041

Manufactured No

100

Each

2.0000

1

1



Aft Upper Rib Assembly



Pl 11.10.12

Location

Loc Qty

Loc Code

WA

1

73933

1

WA006

1

69157

1

B74139 → ①

D4034-043

Manufactured No

100

Each

2.0000

1

1



Fwd Upper Rib Assembly



Pl 11.10.12

Location

Loc Qty

Loc Code

WA

1

73934

1

WA006

1

70241

1

B74146 → ①

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Dart Aerospace Ltd

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Page 5

Work Order ID: 74632

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F Purchased

No

100 sf

571.3581

33

33



Expanded Metal Flat SS



Handwritten: 10.06

Location

Loc Qty

Loc Code

WA

571.35808

117197

102.9036

117896

53.3264

118153

82.2683

118248

33.0983

118597

73.01888

118955

226.7426

Handwritten: 33

AN3-10A

Purchased

No

150 Each

182.0000

6



Bolt



Handwritten: 6

Location

Loc Qty

Loc Code

GA

100

119084

100

ST351

82

117795

66

119128

16

Handwritten: 6

AN960JD8

NAS1149DN832J Purchased

No

150 Each

0.0000

2

2



Washer

D2931

Manufactured

No

150 Each

578.0000

2



Bumper



Handwritten: M1178878

Handwritten: 11/20/08

Location

Loc Qty

Loc Code

ST504

578

46064

578

Handwritten: 2

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Dart Aerospace Ltd

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-5 Manufactured No

150

Each

34.0000

2

2



Blanking Plate



2

Location

Loc Qty

Loc Code

GA

34

73478

34

MS20600-AD4W3

Purchased

No

150

Each

1,457.000

2



Cherry Rivets



2

2

Location

Loc Qty

Loc Code

GA

920

118626

920

ST321

404

111636

48

117505

321

117601

35

WA018

133

107939

133

MS21042L3

Purchased

No

150

Each

11,160.00

6

6



Nut



2

11/10/11

Location

Loc Qty

Loc Code

ST300

2160

117441

16

117601

68

117885

97

118451

979

118927

1000

ST516

6000

119017

6000

ST518

3000

119075

3000

6

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Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

74.0000

12

12



M119225

11/10/11

WASHER

Location

Loc Qty

Loc Code

ST275

74

117735

63

118354

8

17317

3

Dart Aerospace Ltd

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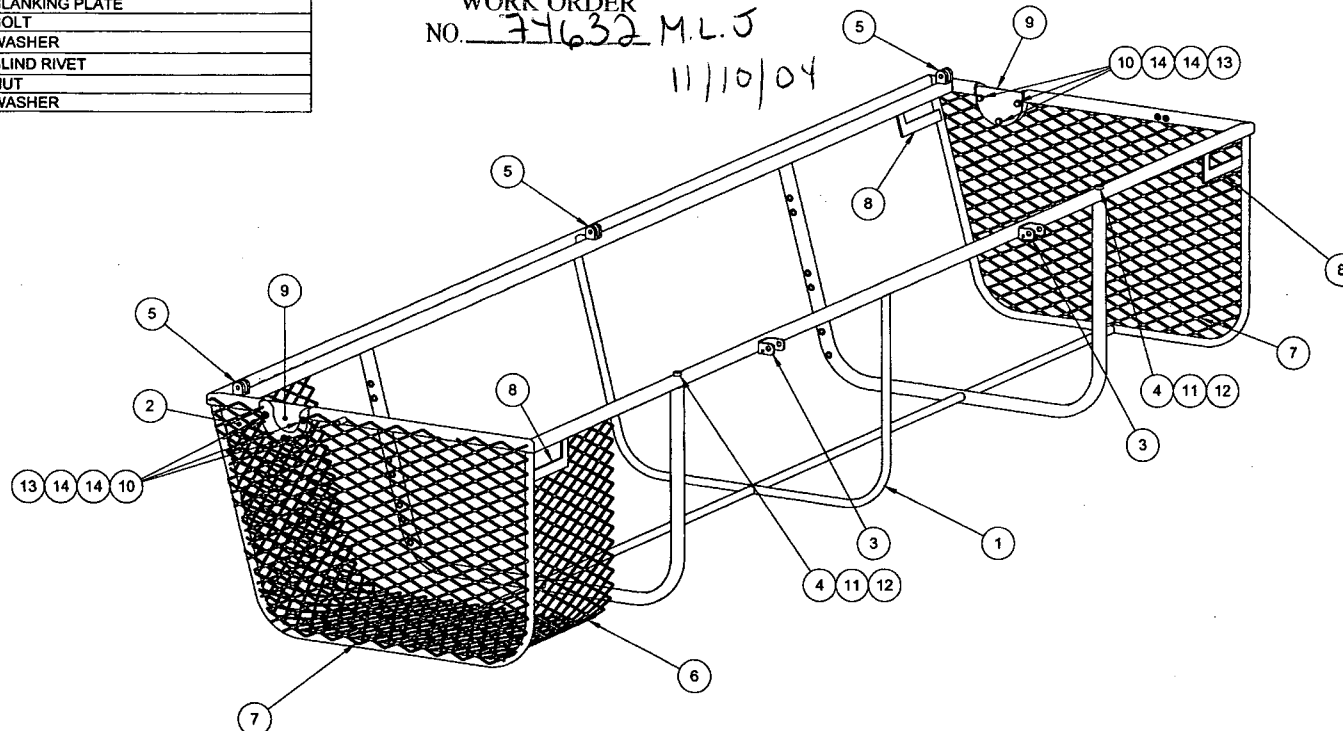
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 77632 M.L.J
11/10/04



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
JPH

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3913	REV. A
TITLE LONG BASKET BASE ASSY (350) NTS	SHEET 1 OF 6
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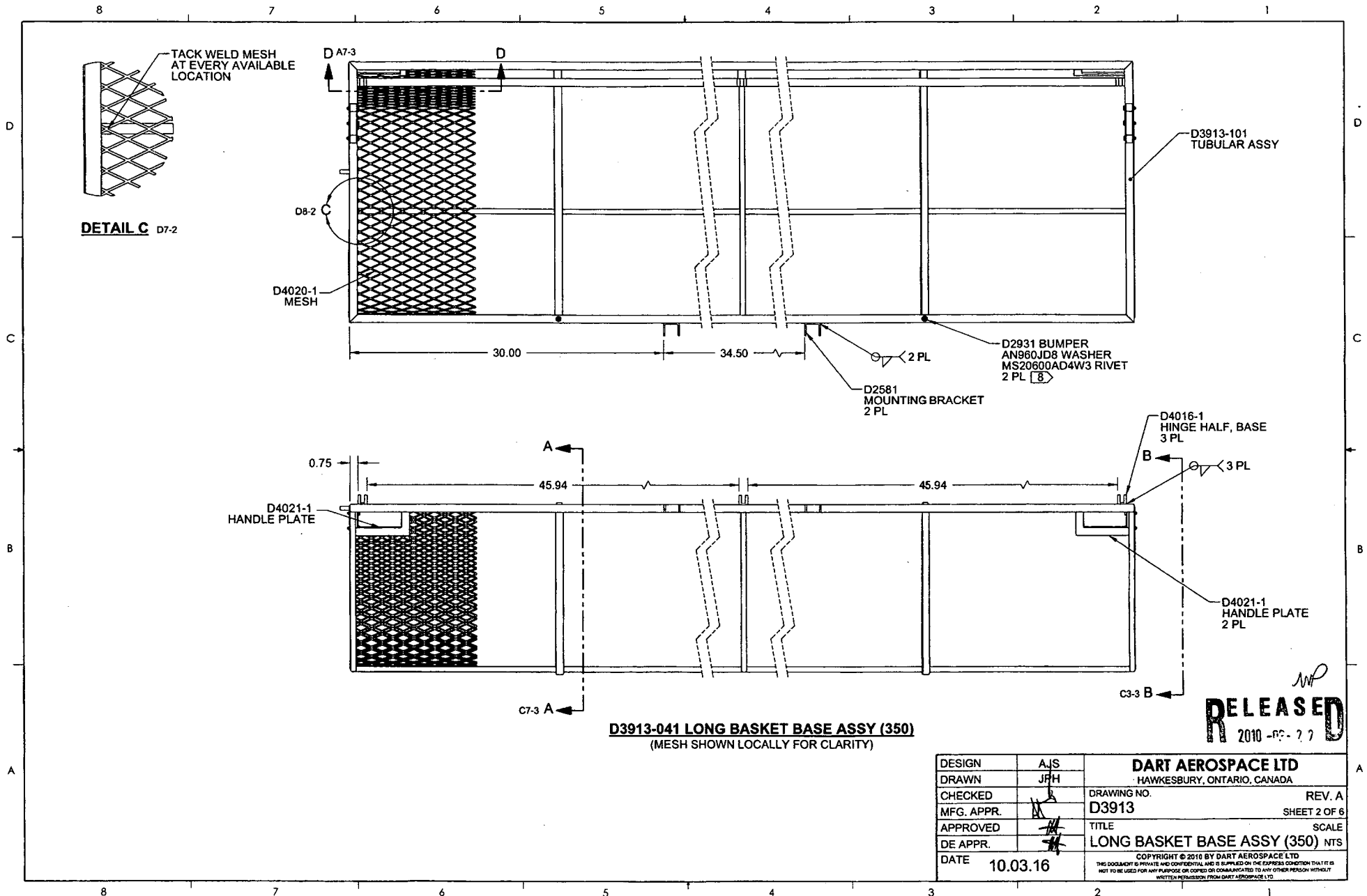
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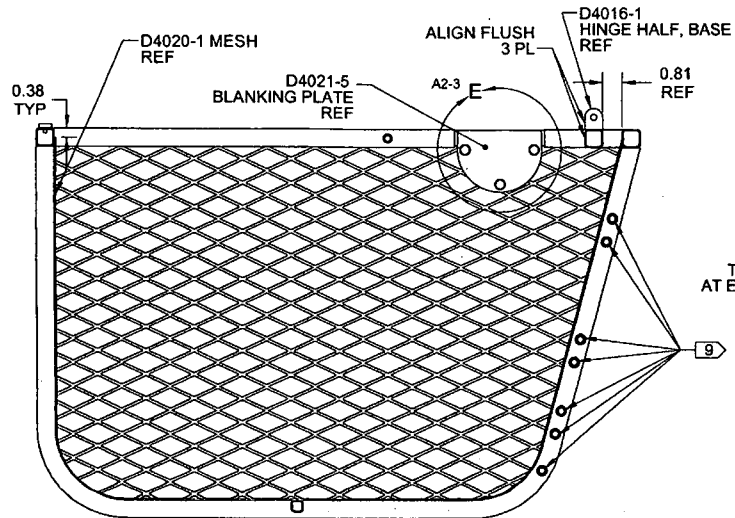
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

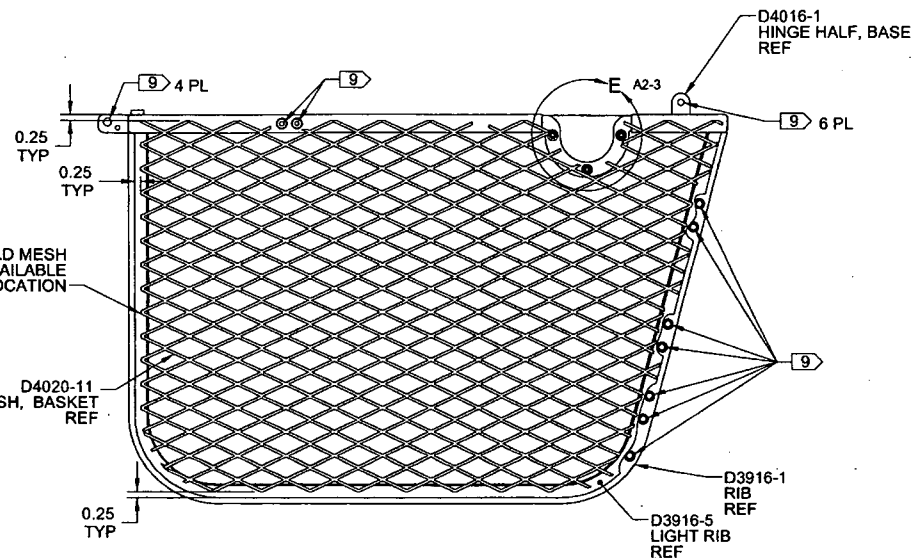
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

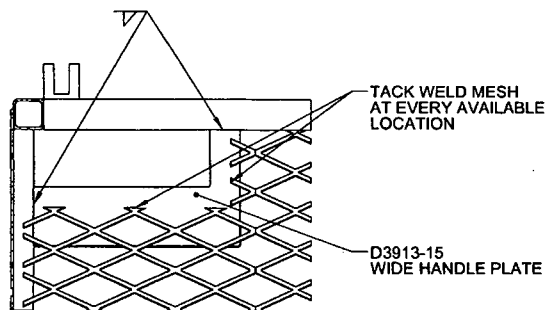
74632



SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES





D4021-5
BLANKING PLATE

AN3-10A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
3 PL

TRIM MESH LOCALLY
Ø 0.50 - Ø 0.60
TO CLEAR FASTENERS

DETAIL E D2-3
D6-3

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

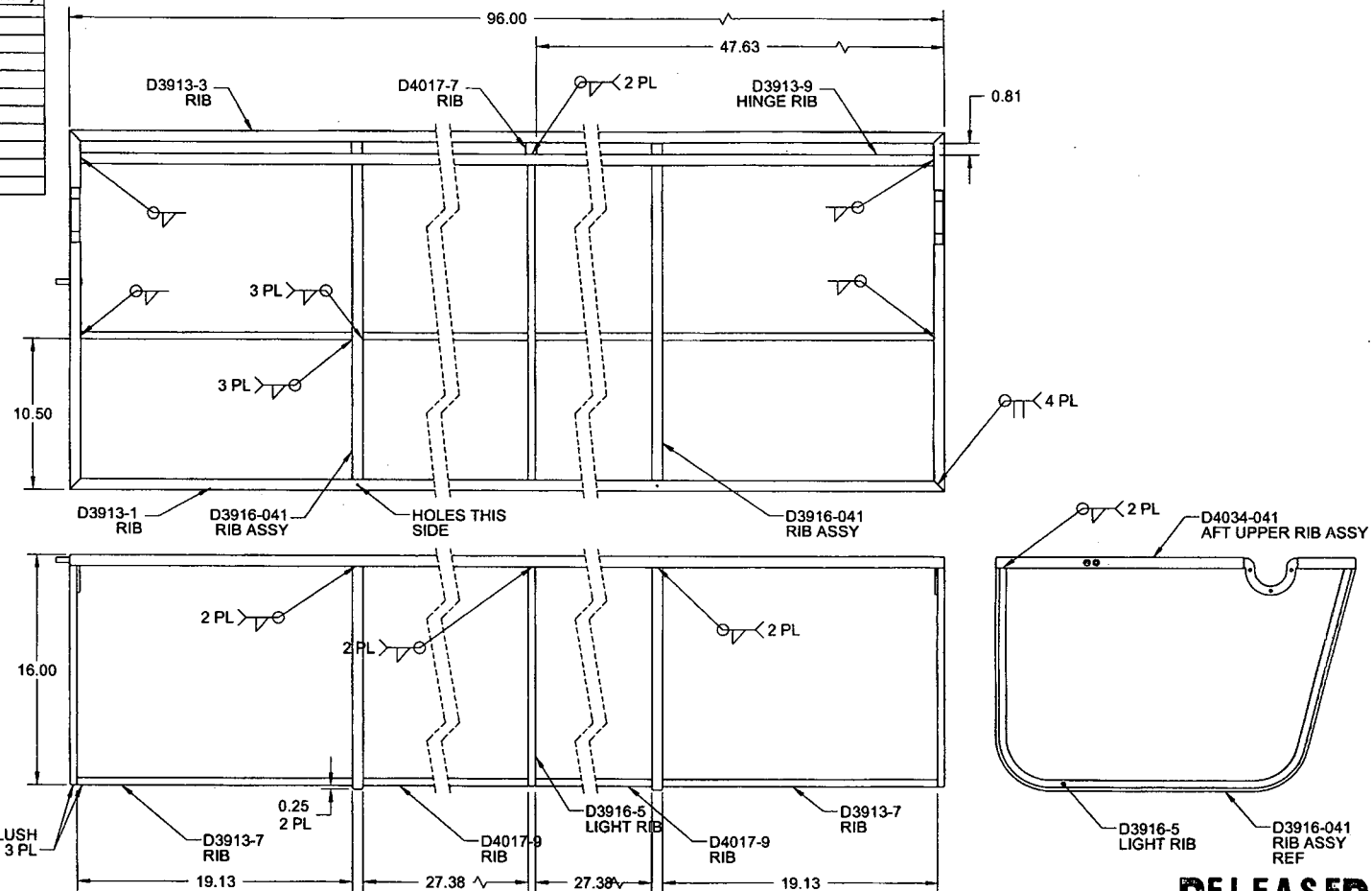
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74632

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. D3913	REV. A
MFG. APPR.		TITLE LONG BASKET BASE ASSY (350) NTS	SHEET 4 OF 6
APPROVED		DATE 10.03.16	SCALE
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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W/O:		WORK ORDER CHANGES					
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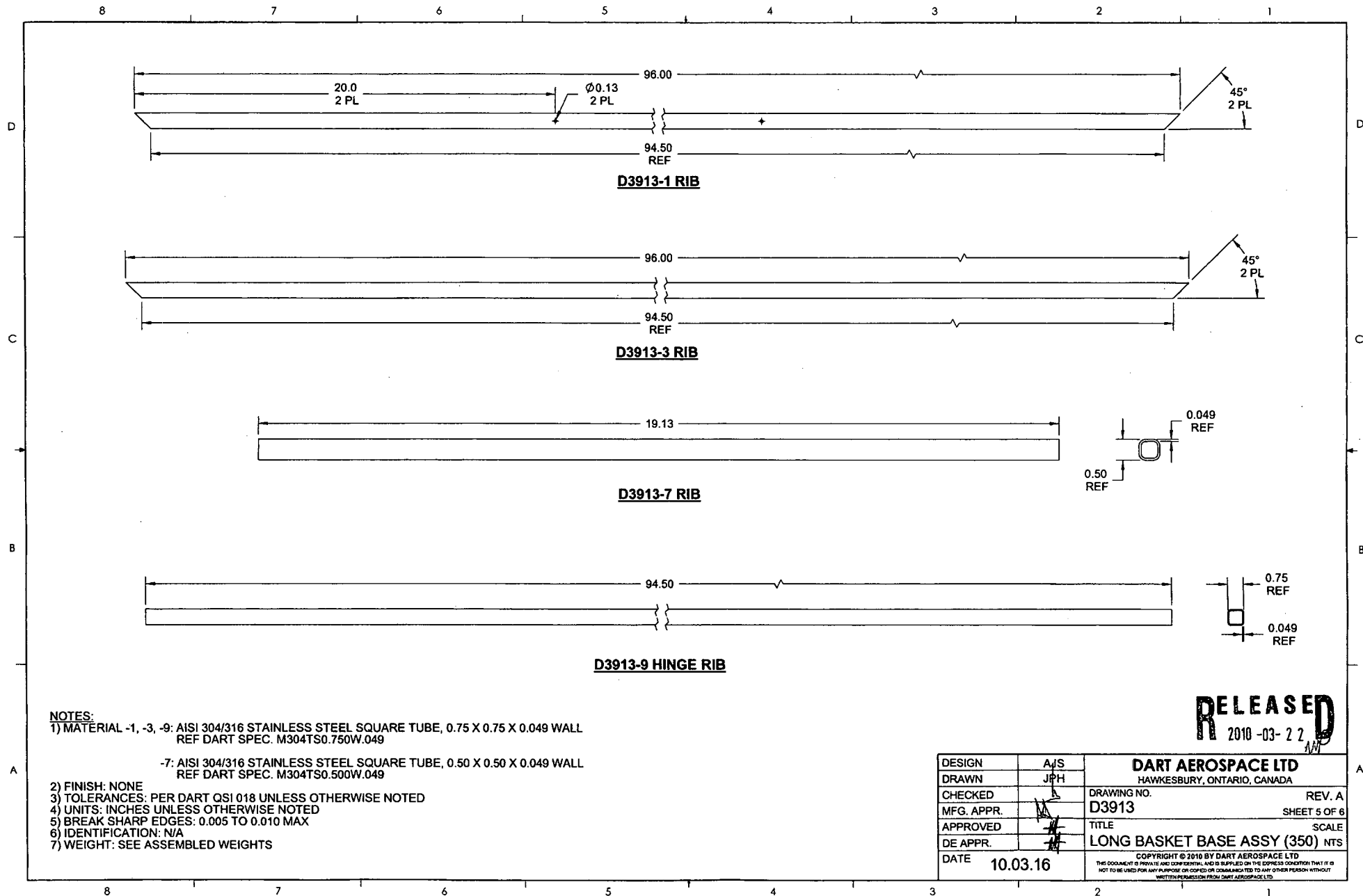
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Dart Aerospace Ltd

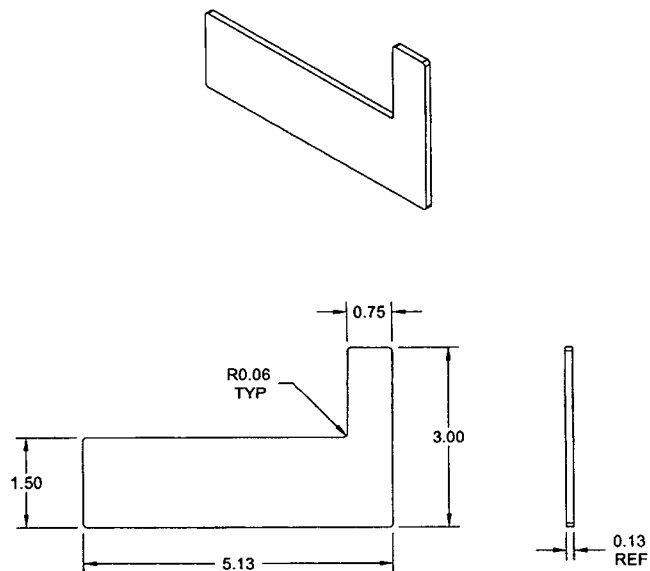
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO. D3913	REV. A
MFG. APPR.		TITLE	SCALE
APPROVED		LONG BASKET BASE ASSY (350) NTS	
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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